









Date: Tuesday, 23/09/2008 10:59:47 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2891-1
Job Number : 42244	
Estimate Number : 13232	
P.O. Number :	Part Number : DSK076
This Issue : 23/09/2008 S.O. No. :	Drawing Number : DSK076 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 41004	Material :
Written By :	Due Date : 30/09/2008 Qty: 10 Um: Each
Checked & Approved By : <u>NO 08.9.23</u>	
Comment : est rev A. 08.03.13 new issue EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	D6104003 Round Billet, 17-4
	
Comment: Qty.: 1 Each(s)/Unit Total: 10 Each(s) Billet Batch: <u>B542736</u> <u>SA 08/11/03</u> (10)	
2.0	MORI SEIKI MORI SEIKI CNC LATHE LARGE
	
Comment: MORI SEIKI LATHE Turn blank for as per Folio FA046 <u>SA 08/11/03</u> (10)	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 08/11/03</u> (10)	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>SA 08/11/03</u> (10)	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1 Identify and Stock in Kanban Location: <u>CNC</u> <u>SA 08/11/03</u> (10)	
6.0	QC21 FINAL INSPECTION/W/O RELEASE
	
Comment: FINAL INSPECTION/W/O RELEASE <u>SA 08/11/07</u> (10)	
Job Completion  <u>MF 08-11-06</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4224
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.276	2.277	2.276	2.276	2.276
B	3.702	3.722		3.708	3.705	3.708	3.708	3.708
C	2.564	2.584		2.578	2.577	2.578	2.578	2.578
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.103	.102	.102	.102	.102
F	2.464	2.484		2.474	2.474	2.474	2.475	2.474
G	2.029	2.049		2.036	2.041	2.041	2.040	2.040
H	2.964	2.984		2.975	2.974	2.974	2.974	2.974
I	0.913	0.933		.920	.923	.923	.923	.923
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.098	.097	.098	.098	.098
L								
M								
N								
O								
P								

Measured by: SA Date: 08/11/03

Audited by: RC Date: 08/11/03

Prototype Approval: # Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

DART AEROSPACE LTD		Work Order: 42244
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

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K	0.090	0.110		.098	.098	.098	.098	.098
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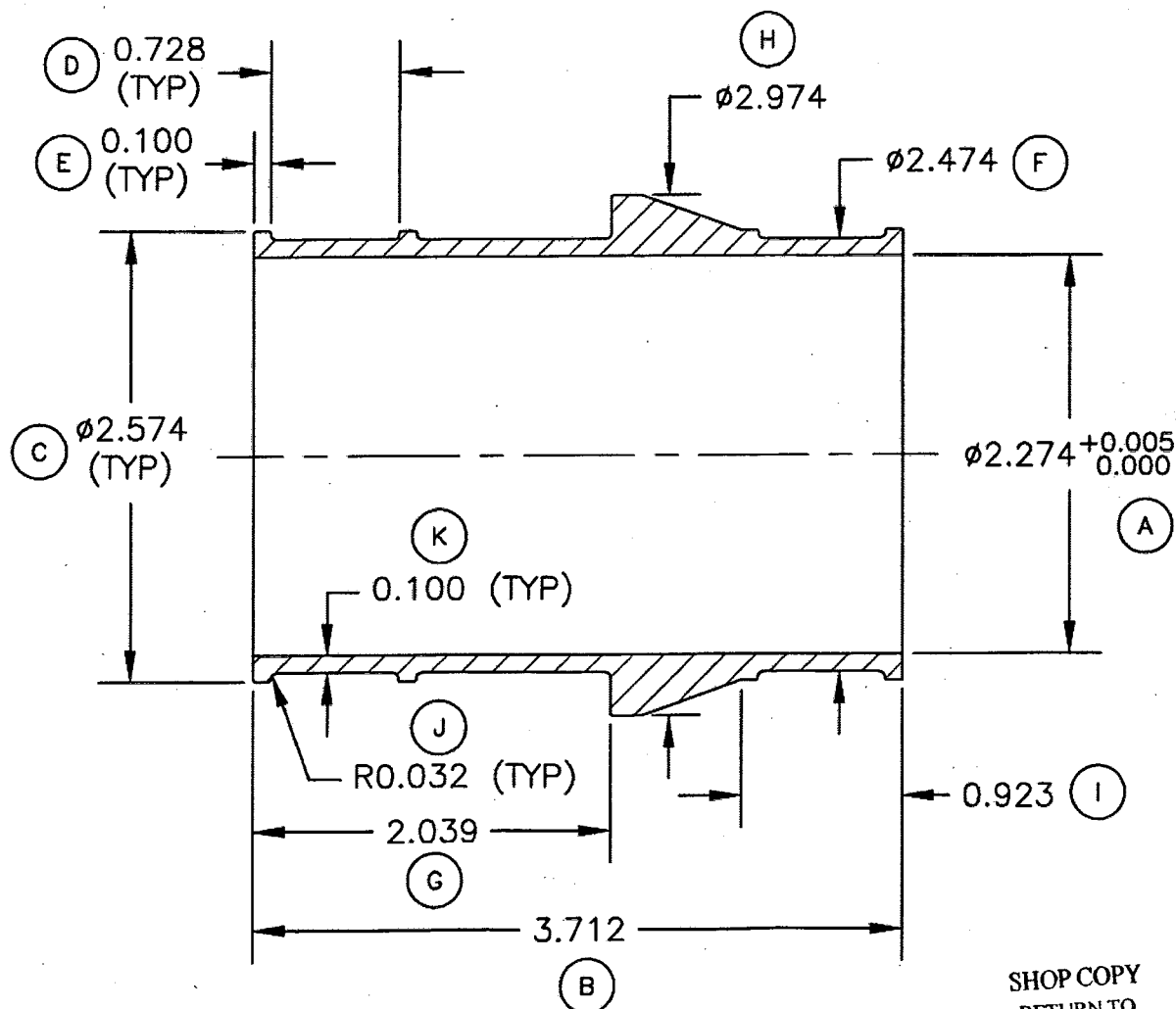
Measured by: SA	Date: 08/11/05
Audited by: [Signature]	Date: 08/11/05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]



D2891-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 472244

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